

Work Order ID 151969

Friday, October 14, 2016 1:56:17 PM

151969

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Item ID: D119-796-251 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: AFT Crosstube Installation with Step (no hardware)
Start Date: 10/28/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/23/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference: **DAS 21**

Approvals: Process Plan: **9-89** Date: **OCT 17 2016** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D119-796-251	D								
110	Document Control	0.00						DAS 21 9-89	DEC 14 2016
110									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D119-796-251 chg 002								
120	Pick Kit	0.00							
120	Packaging								
Packaging	Memo	0.00							
Packaging									
130	Crosstubes	0.00							
130									
Crosstubes	Memo	0.08							
Crosstubes	1- Install step and clamp with the proper position per dwg D119-796-251								
	Torque all clamps to 50 IN-LBS max.								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo ***RE-CHECK TORQUE ON CLAMP AS PER DWG.*** ***VERIFY BY <u>151969</u> DAS 38 BATCH # TO MATCH W/O ***VERIFY BY <u>151969</u> DAS 38 PART # TO MATCH W/O <u>151969</u> DAS 38	0.00 0.00				<u>1</u>			DAS 38 9-89 DEC 17 2016
150 *150* Packaging Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D119-796-251 Au1	0.00 0.00				<u>1</u>			DAS 41 9-89 16-12-13
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.02						DAS 21 9-89	DAS 21 9-89 DEC 14 2016

DEC 13 2016

Picklist Print

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Work Order ID: 151969

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Parent Item: D119-796-251

D119-796-251

Parent Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 10/28/2016

Required Date: 11/23/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP REV:B
14.10.15 AS PER REV.A DD VERF:JLM IPP REV:C 14.11.19
AS PER REV.C DD VERF:JLM IPP REV:D 14.12.09 AS PER
REV.PC6 DD VERF:JLM IPP REV:E 15.02.11 AS PER REV D
JLM VERF:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D119-796-241

Manufactured No

Each 1.0000

1

DAS

D119-796-241

AFT Crosstube Installation without Step (no hardware)

**

41

16-12-4

Location

Loc Qty

Loc Code

FG

1

146580

1

D5123-3

Manufactured No

Each 126.0000

4

DAS

D5123-3

Clamp Cushion

**

41

9-89

16-12-4

Location

Loc Qty

Loc Code

LG055

126

149113

16

149671

12

150315

48

151097

50

4

D5149-043

Manufactured No

Each 8.0000

2

D5149-043

Aft Step Base Assembly

**

16-12-11

Location

Loc Qty

Loc Code

LG055

8

146877

4

148182

2

150305

2

151094

2

Picklist Print

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Work Order ID: 151969

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Parent Item: D119-796-251

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Parent Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 10/28/2016

Required Date: 11/23/2016

Start Qty: 1.00

Required Qty: 1.00

MS21920-25

Purchased

No

Each

172.0000

4

DAS

MS21920-25

41

9-89

16-12-4

Clamp

Location

Loc Qty

Loc Code

FG

4

120920

2

m134987

2

LG050

168

m135538

2

m135647

24

m135653

42

m135707

50

m135708

8

m135717

25

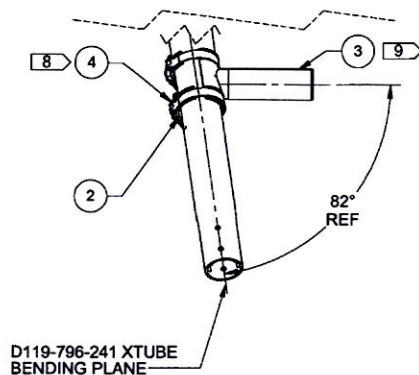
m135787

17

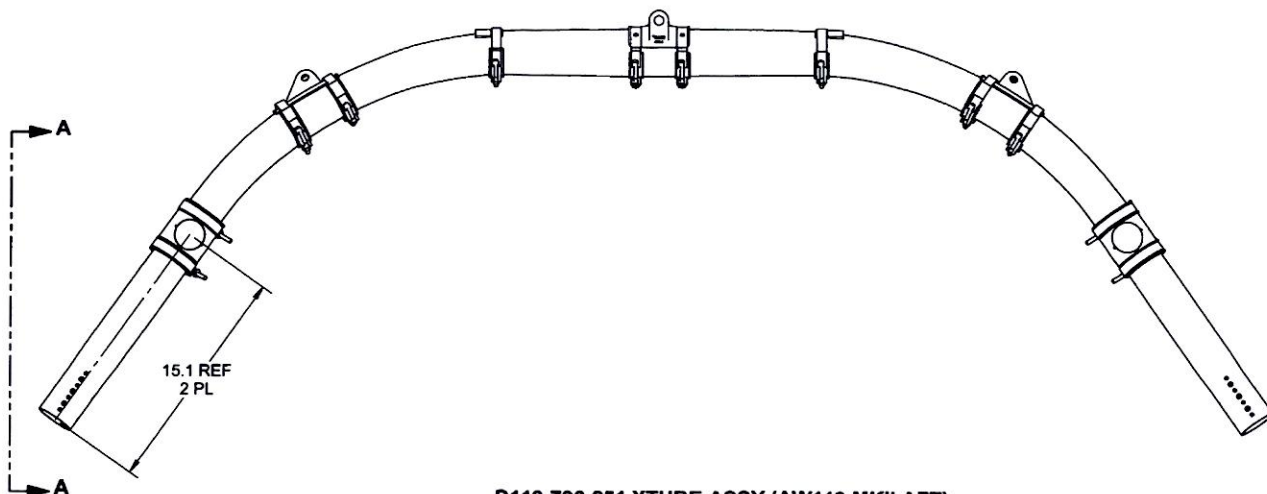
4

1 → Scrap

ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
1	1	D119-796-241	XTUBE ASSY (AW119 MKII AFT)
2	4	D5123-3	CUSHION
3	2	D5149-043	AFT STEP ASSY
4	4	MS21920-25	CLAMP



SECTION A-A



D119-796-251 XTUBE ASSY (AW119 MKII AFT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 29.9 lbs
- 8) TORQUE MS21920-25 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 151969 MLC

16-10-17

RELEASED

2015 FEB 09

ECN 15-516

D	D5123-3 WAS D5123-9, MS21920-25 WAS -26, ADDED SECTION A-A	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D2274 RADIUS BLOCK WAS D5153-1, AN4C12A WAS AN4C10A	AP	14.10.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D119-796-251 TITLE XTUBE ASSY (AW119 MKII AFT)	REV. D
DRAWN	AP		SHEET 1 OF 1
CHECKED	DB		SCALE
MFG. APPR.	DD		NTS
APPROVED	HS		
DE APPR.	DS		
DATE	15.01.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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